

Work Order ID 87097

July-10-12 3:13:38 PM

87097

Page 1

Item ID: D3901-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 7/09/12 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: *[Signature]* Date: 120711 Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3901	C

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 80.25"

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB090 & dwg D3901,

FOLIO REV: E

DWG REV: E

2-Deburr as required

FK - 12/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 87097***87097***

Page 3

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Item ID: D3901-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 7/09/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 12/08/12

12-08-12

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Picklist Print

July-10-12 3:13:38 PM

Page 1

Work Order ID: 87097

Parent Item: D3901-5

Parent Item Name: Bar

Start Date: 7/09/12

Required Date: 8/03/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:JLM

IPP RevB: Now on cnc JFS 12/02/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	566.4540	6.648	27.991579		8/2 12/08/13	

Location

Loc Qty

Loc Code

MAT050

566.454

121216

142.08

121547

63.904

→ 122008

360.47

~~6.7~~ 28.0

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	87097
Description: Bar		Part Number:	D3901-5
Inspection Dwg: D3901	Rev: B C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.490	✓		FK-04	Vern.
0.20 0.25"	+/-0.030	.25	✓		"	"
0.130" → 0.080	+/-0.010	.136	✓		"	"
1.50	+/-0.030	1.50	✓		"	"
4.00" → 4.02	+/-0.030	4.00	✓		"	"
26.00	+/-0.030	26.00	✓		FK-05	Tape
45.62	+/-0.030	45.62	✓		"	"
51.12	+/-0.030	51.12	✓		"	"
61.12	+/-0.030	61.12	✓		"	"
69.62	+/-0.030	69.62	✓		"	"
74.27" → 74.29	+/-0.030	74.27	✓		"	"
79.77" → 79.72	+/-0.030	79.77	✓		"	"

Measured by: F.K.	Audited by: <u> </u>	Prototype Approval:	N/A
Date: 12/08/14	Date: 12-08-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u> </u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

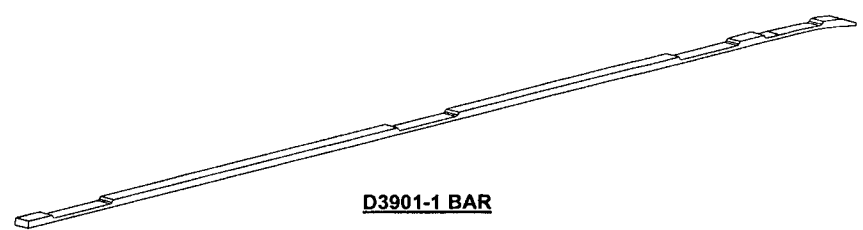
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

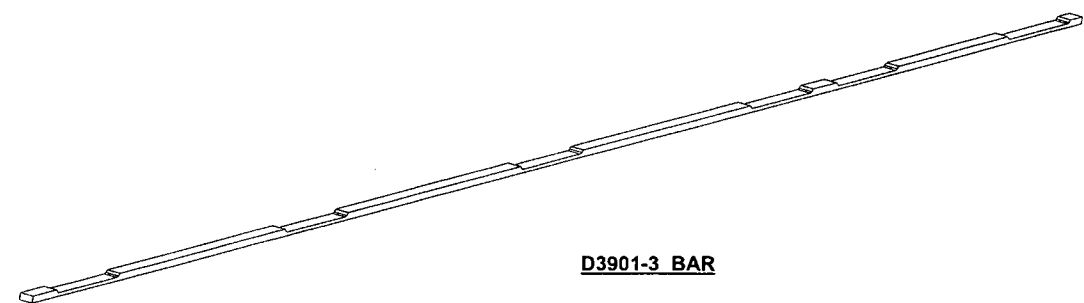
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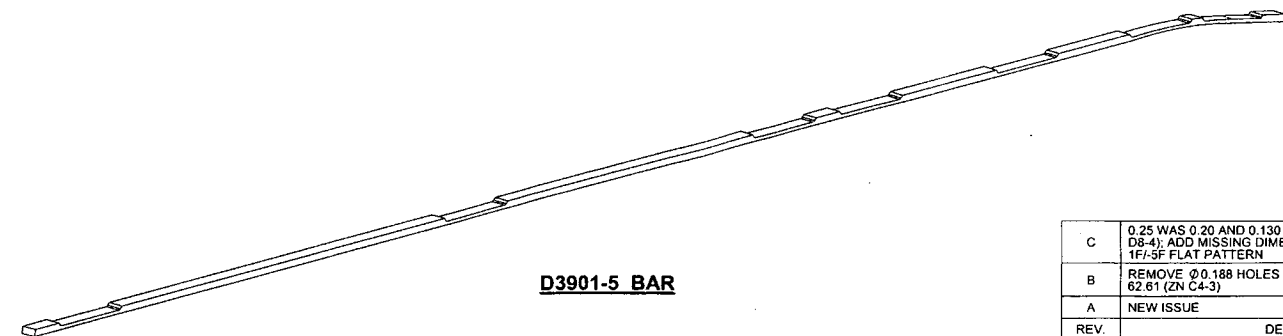
8-1097
R/12-07-11



D3901-1 BAR



D3901-3 BAR



D3901-5 BAR

RELEASED
2012-06-27

REV.	DESCRIPTION	BY	DATE
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F-5F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1F-3F-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D3901	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	BAR	NTS
DE APPR.	RF	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	12.01.24		

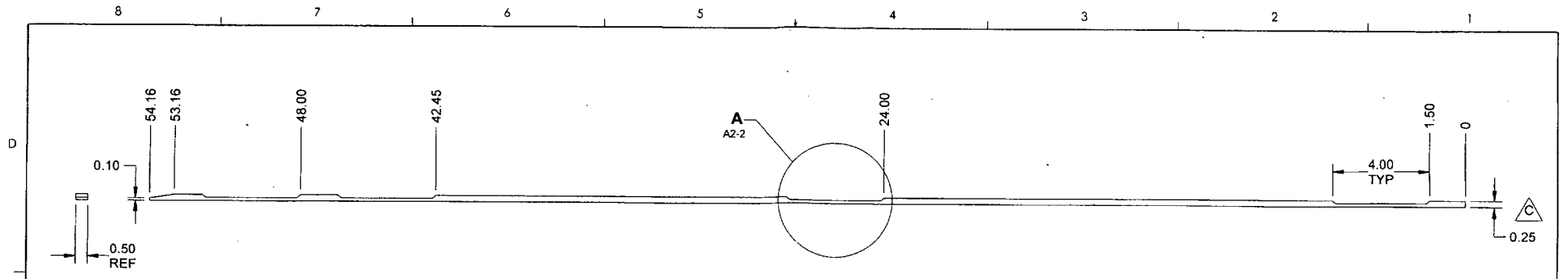
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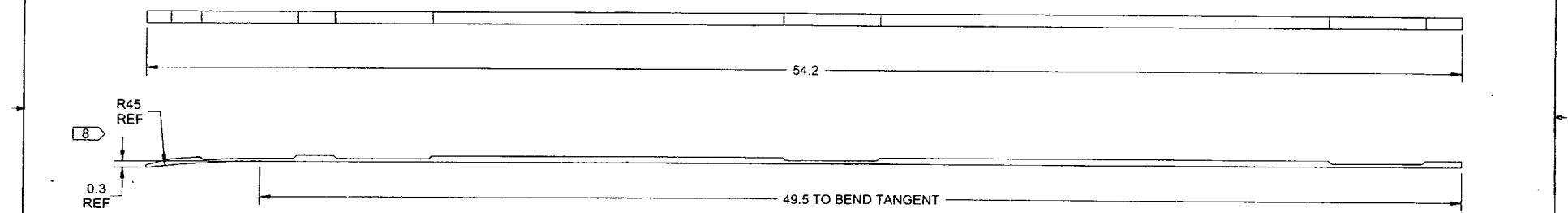
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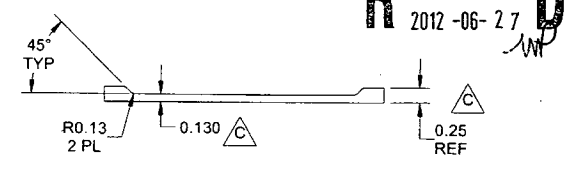
NOTE: Date & initial all entries



D3901-1F BAR FLAT PATTERN



D3901-1 BAR
(MAKE FROM D3901-1F)



DETAIL A D4-2
TYP. SCALE 2X B4-3
D2-4

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.68 lbs
 - 8) FORM TO FIT WEARPLATE

87097

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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2012-06-27

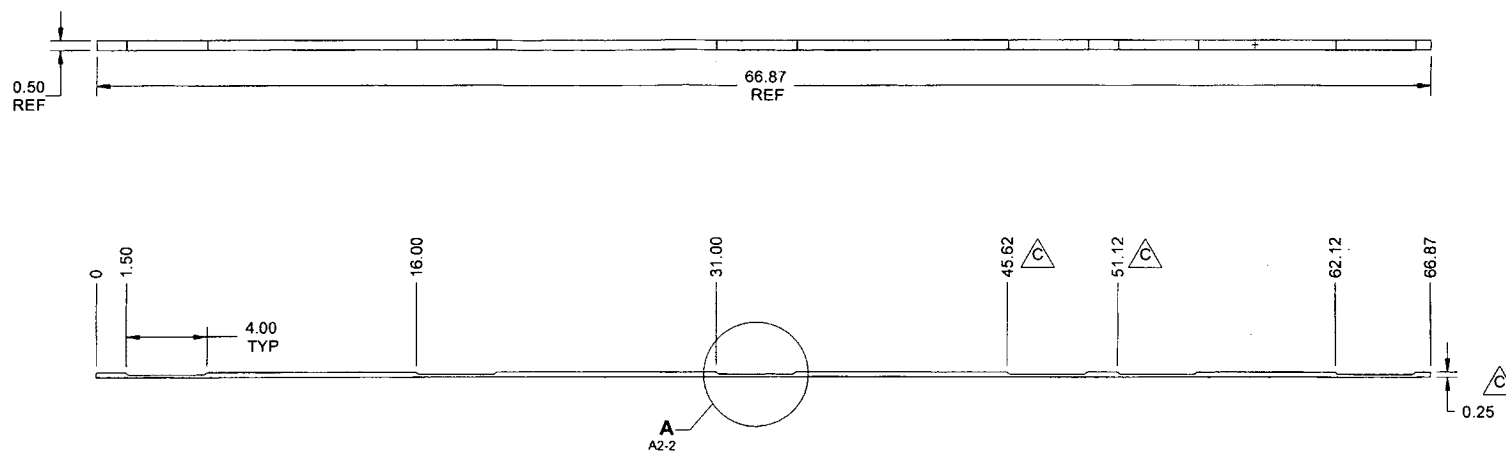
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NOTE: Date & initial all entries



D3901-3 BAR

57097

RELEASED
2012-06-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3901	SHEET 3 OF 4
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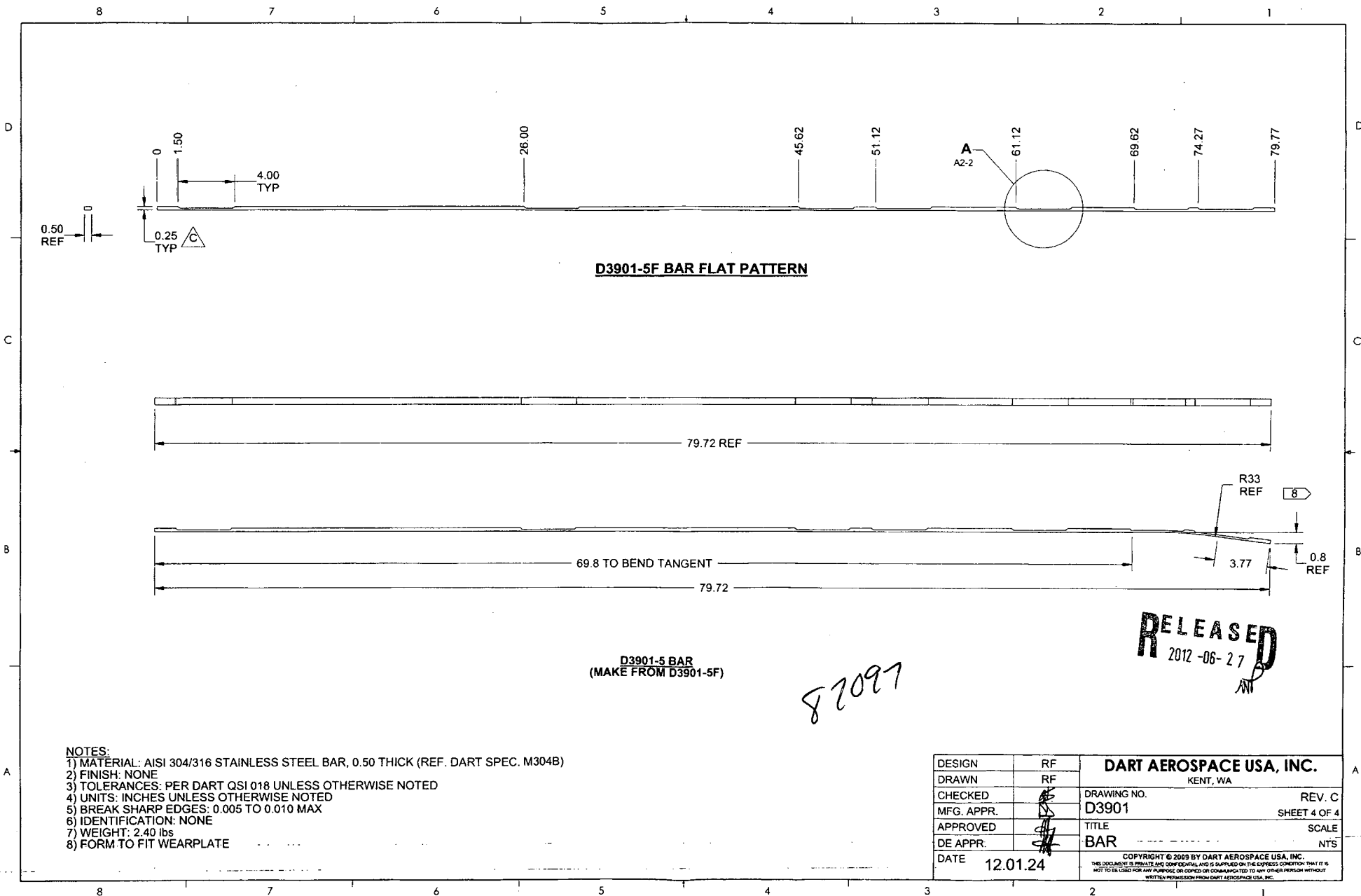
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